

Deriv. 55381

Work Order ID 48387

June 26, 2009 12:39:46 PM



Item ID: D3560-043  
Revision ID: D  
Item Name: Arm Weldment

Accept



Setup Start  
Stop



Start Date: 15/07/2009 Start Qty: 8.00  
Required Date: 03/08/2009 Req'd Qty: 8.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3560	Rev D								
100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blanks 15.500" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo 1- Mill as per Folio FA695 Rev: _____ & Dwg D3560 Rev: _____ 12-C'sink 0.196" hole on manual mill as per dwg D3560 13-Deburr per dwg D3560								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

# Work Order ID 48387

June 26, 2009 12:39:46 PM

Page 2

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Start Date: 15/07/2009 Start Qty: 8.00

Required Date: 03/08/2009 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad ) 2- set up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to 135 amps 6- weld across

10.01.06  
(see dd w/o)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> Solved

(x7)

**Work Order ID 48387**

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Page 3

Item ID: D3560-043

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Start Date: 15/07/2009 Start Qty: 8.00

Required Date: 03/08/2009 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.01.07 (7)

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-01-11 (7)

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAP 10-01-11 (7)

# Work Order ID 48387

June 26, 2009 12:39:46 PM



Page 4

Item ID: D3560-043  
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Setup Start  
Stop



Start Date: 15/07/2009 Start Qty: 8.00  
Required Date: 03/08/2009 Req'd Qty: 8.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

9510/01/12 (7)

200

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

⇒ 8/06/13

(7)

7

210

0.00



Identify as per dwg & Stock Location: WA

Packaging

Memo

0.00

Packaging

SAD

10-01-14

7

# Picklist Print

June 26, 2009 12:39:45 PM

Page 1

Work Order ID: 48387

Parent Item: D3560-043RevD

Parent Item Name: Arm Weldment




Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2808RevB 		Manufactured	No			100	Each	0.0000	8.0000			
Bushing M6061T6B0.500X05.00 0 		Purchased	No			140	f	0.0000	10.9053			
6061-T6 Bar .500 x 5.00 ✓ D3592-1RevB 		Manufactured	No			190	Each	0.0000	8.0000			
Plate												

B42181 (H)

B46738 (W)

EP 10/01/12



1/2 347015 10.01.05 = 7

Date: Monday, 08/06/2009 9:24:30 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM
<b>Job Number</b> : 48387	
<b>Estimate Number</b> : 12883	
<b>P.O. Number</b> :	<b>Part Number</b> : D3560043
<b>This Issue</b> : 08/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3560 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 47865	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/06/2009 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.08.08</u>	
<b>Comment</b> :	
Est Rev:A New Issue 07.05.24 EC	
Est Rev B ECN 987 07.10.09 EC	
Est Rev:C ECN1048 07-12-18 DD verified by: EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
-----	--------------------	-------------------------



**Comment:** Qty.: 1.3598 f(s)/Unit Total: 10.8780 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M111408 x 3 parts scrap 3" diam.

8/09/06/09

2.0	BAND SAW	BAND SAW
-----	----------	----------



**Comment:** BAND SAW

Cut blanks 15.500" long

8/09/06/09

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

J.L 09/06/09

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 08/06/2009 9:24:30 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 48387

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8/09/06/10

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLATE 347015

8/09-06-23

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad ) *th*
- 2- set up bracket and arm on jig *th*
- 3- preheat bracket and arm with torch *th*
- 4- clean before welding with brush *th*
- 5- set up machine to 135 amps *th*
- 6- weld across bottom and top ends *th*
- 7- reheat with torch ( 65 deg C ) *th*
- 8- on one side weld from bottom to top half way *th*
- 9- same for other side (half way) *th*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *th*
- 11- same for remaining side (ease off pedal near end) *th*

8/10-01-06

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/10-01-06

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8/10-01-07 (7)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8/10-01-11 (7)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3560-043 <sup>CAR 10-001</sup> PAR #:            Fault Category: large Fms NCR: Yes No DQA: HA Date: 10.01.19  
 Resolution: Re-weld Disposition: Re-weld QA: N/C Closed: HA Date: 10/02/11

NCR: <u>48381</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.01.06	7.0	1 arm cracked bottom left side  R.C: process	<u>HA</u> <u>12/11/12</u>	Zip cut out weld in spot of crack and re welded per Q31004	<u>HA</u> 10.01.06	<u>S</u> 10/01/11	<u>HA</u> 12/11/12	<u>HA</u> 10/01/06

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 9:24:30 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 48387

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD

10-01-11

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

batch:

46738

(6+)

B42181

(X)

25/01/12

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

25/01/12

(7)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26/01/13

(7) (242)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

WA

SAD 10-01-14

(7)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 48387
<b>Description:</b> Arm		<b>Part Number:</b> D3560-3
<b>Inspection Dwg:</b> D3560	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

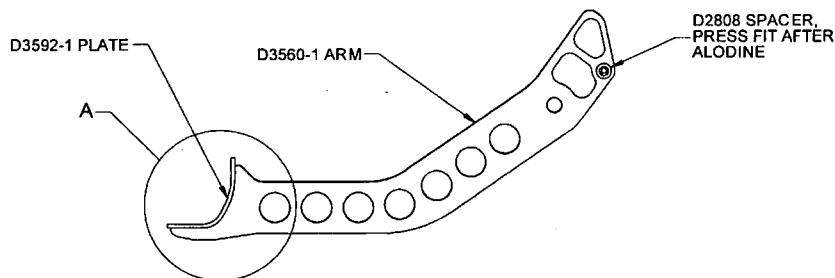
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5067	✓			
Ø0.196	+0.005/-0.001	.196	✓			
Ø1.000	+0.010/-0.001	1.007	✓			
Ø0.900	+0.010/-0.001	.905	✓			
0.500	+/-0.010	.493	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.275	✓			
0.188	+/-0.010	.189	✓			
1.750	+/-0.010	1.749	✓			
1.702	+/-0.010	1.703	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380x100°	✓			
0.250 Deep	+/-0.010	.246	✓			

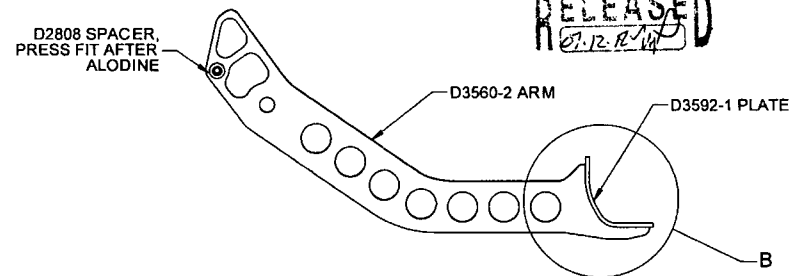
<b>Measured by:</b> J.L.	<b>Audited by:</b> JB	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/06/09	<b>Date:</b> 09/06/10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.09.09	2.000 dimension removed	KJ/DD	

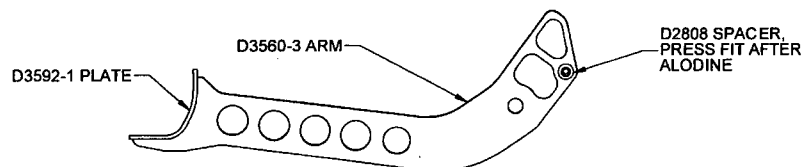
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D.R. R.M.



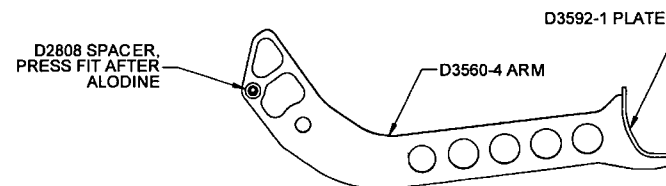
**D3560-041 ARM WELDMENT**



**D3560-042 ARM WELDMENT**



**D3560-043 ARM WELDMENT**



**D3560-044 ARM WELDMENT**

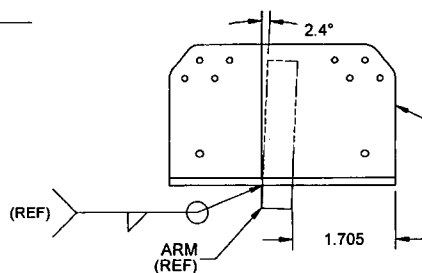
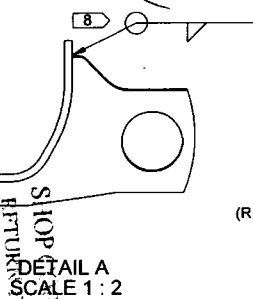
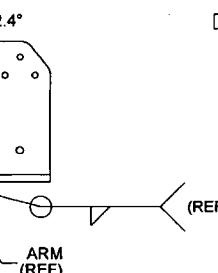
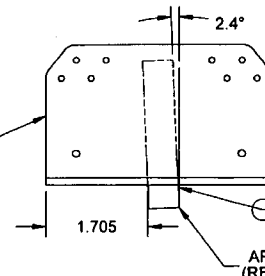


PLATE (REF)



**DETAIL B  
SCALE 1 : 2**

**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

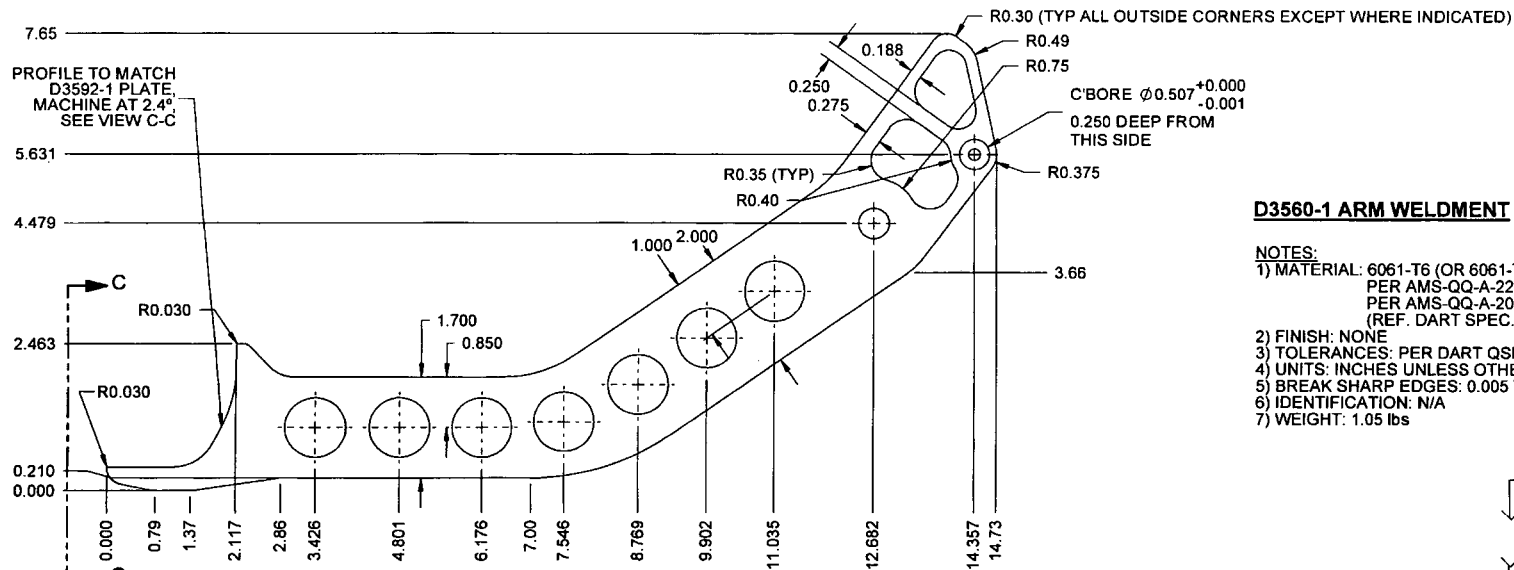
DRAWING NO. **D3560** REV. D  
SHEET 1 OF 5  
TITLE **ARM WELDMENT** SCALE 1:4

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STOP  
COPY  
FOR  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 18381

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.23 lbs (TYP)
  - 8) WELDING: PER DART QSI 004

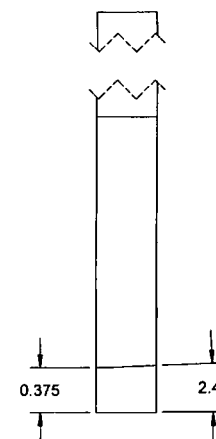
PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW C-C



### D3560-1 ARM WELDMENT

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

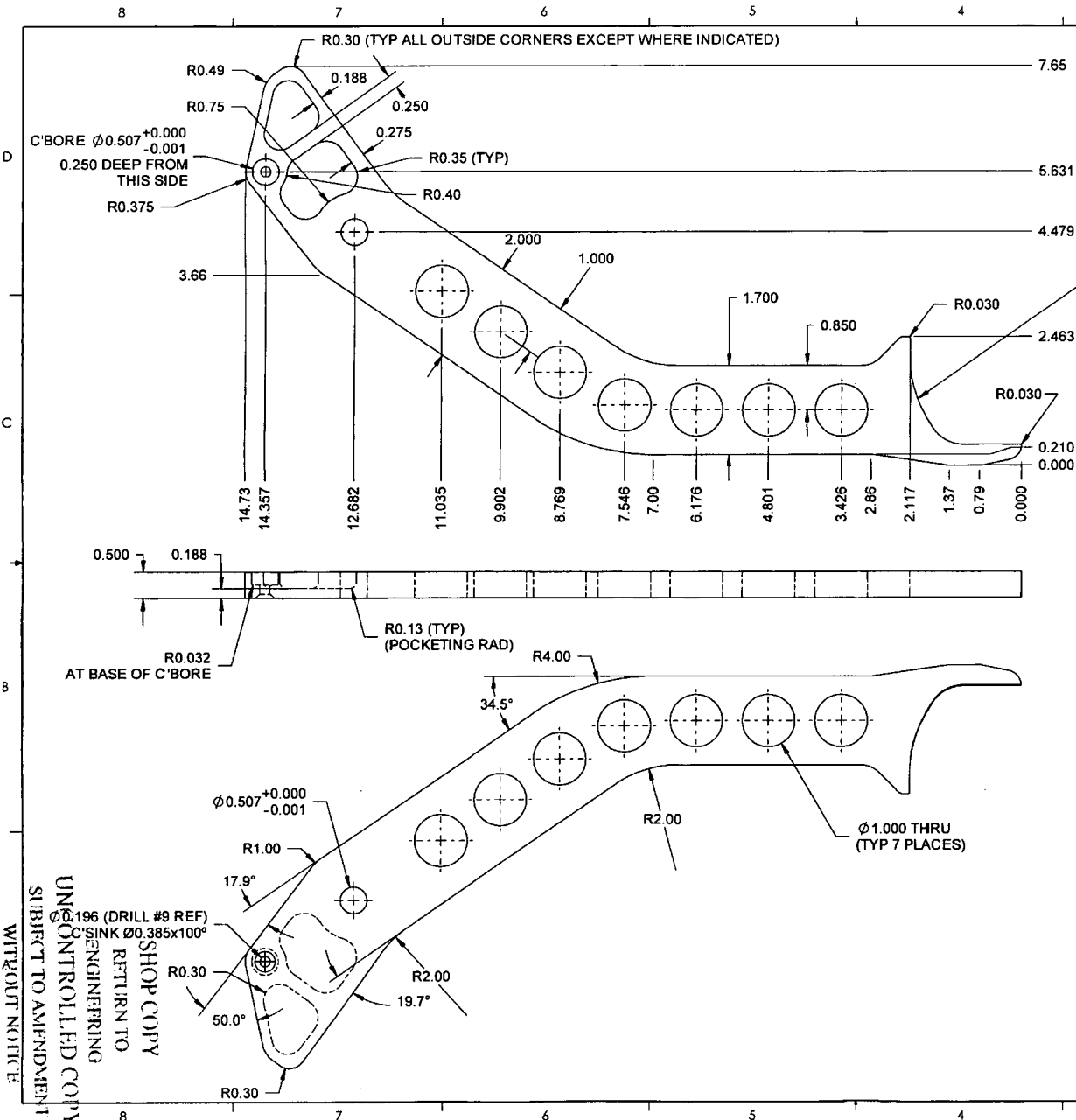


VIEW C-C  
SCALE 1:1

RELEASED  
07.12.16

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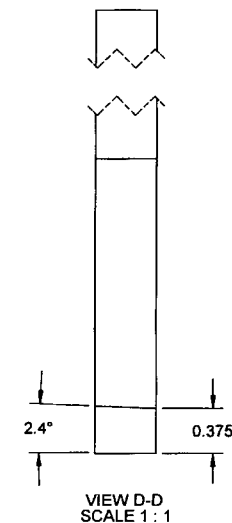
DESIGN	QC	<b>DART AEROSPACE LTD</b>	
DRAWN	QC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QC	DRAWING NO.	REV. I
MFG. APPR.	QC	D3560	SHEET 2 OF 5
APPROVED	QC	TITLE	SCALE
DE APPR.	QC	ARM WELDMENT	1:
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4°,  
SEE VIEW D-D

### D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs

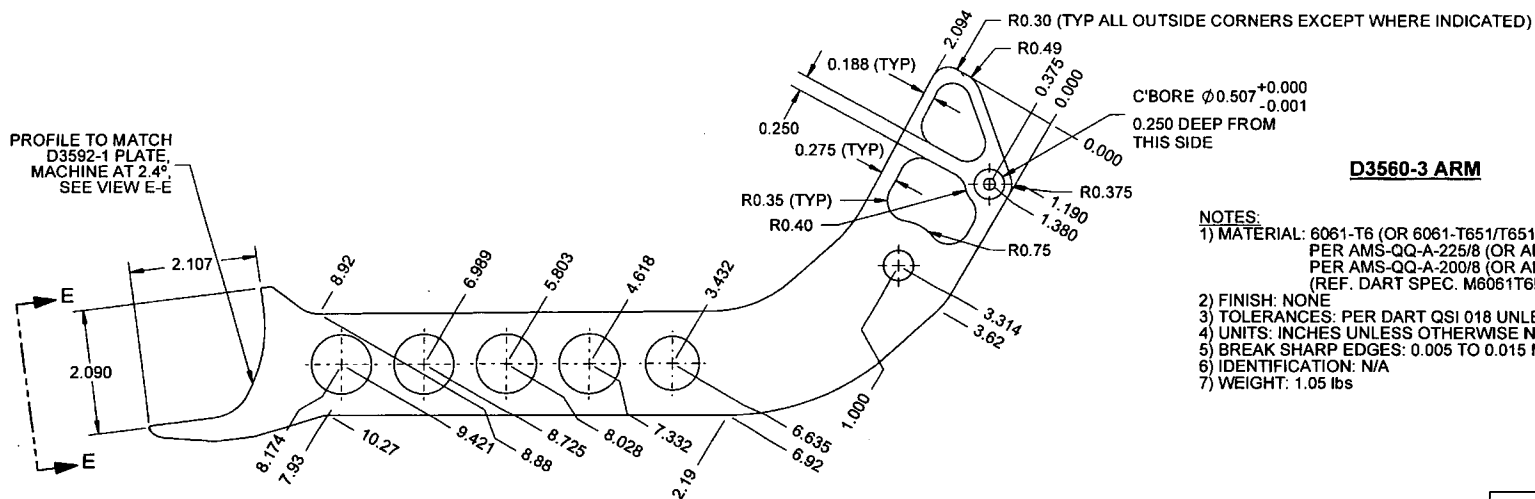


DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3560</b>	REV. D
MFG. APPR.		SHEET 3 OF 5	
APPROVED		TITLE <b>ARM WELDMENT</b>	SCALE 1:2
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	07.11.16	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NO  
48387  
WORK ORDER  
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RELEASED  
07.12.16

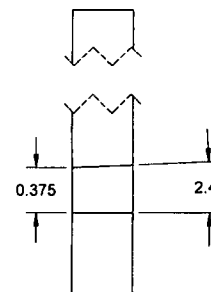
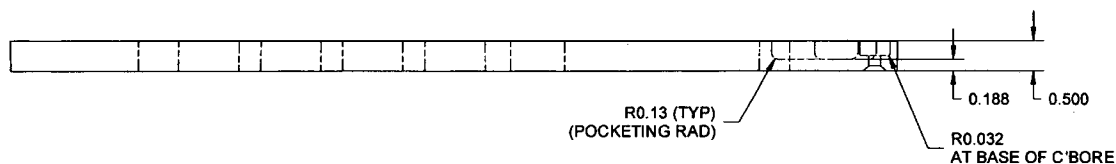
PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E



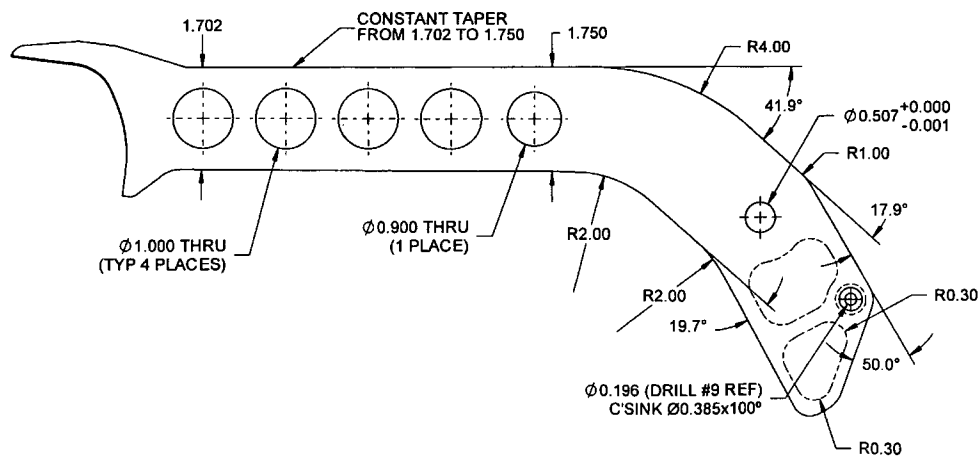
### D3560-3 ARM

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW E-E  
SCALE 1:1



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DESIGN	q	<b>DART AEROSPACE LTD</b>	
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CHECKED	dc	DRAWING NO.	REV. D
MFG. APPR.	dc	<b>D3560</b>	SHEET 4 OF 5
APPROVED	dc	TITLE	SCALE
DE APPR.	dc	<b>ARM WELDMENT</b>	1:2
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